

# Work Order ID 51241

August 12, 2009 8:14:10 AM



Page 1

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Replacement Window Assembly					
Start Date:	08/12/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	08/24/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>yuf</u>	Date:	<u>09-08-12</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D3290	Rev C					2			

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290 ( use prog. for D3290-1) <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog								
	Rev: <u>C</u> <input type="checkbox"/> 2-Deburr if necessary								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

2) 509/08/13

B 9-8-12

B 9-8-12

2

12 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3290-041

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Setup Start



Revision ID: C

Stop



Item Name: Replacement Window Assembly

Start Date: 08/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Handwritten: 08/08/13 (X2)

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Handwritten: 11/12/20  
START TIME: 2:00pm FINISH TIME: 2:30pm OVEN TEMPERATURE: 320°F

Handwritten: 08-08-13 (X2)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: 08/08/13

Handwritten: (X2)

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Page 3

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Item Name: Replacement Window Assembly

Start Date: 08/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

SAI 09-08-14 (2)

Small Fab

Assemble as per Dwg D3290 □ Clean D3290-041 and place in plastic wrap

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

⇒ 09/08/14



✱

Quality Control

180

0.00



Identify as per dwg & Stock Location: 219

Packaging

Memo

0.00

9/8/14 (2) Sp

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 51241**

August 12, 2009 8:14:10 AM



Page 4

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Item Name: Replacement Window Assembly

Start Date: 08/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/14

MK 09-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

August 12, 2009 8:14:09 AM

Page 1/2

Work Order ID: 51241



Parent Item: D3290-041RevC



Parent Item Name: Replacement Window Assembly

Start Date: 08/12/2009

Required Date: 08/24/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2126RevC		Manufactured	No			160	f	522.2000	6.5000			
Seal												

SAD 09-08-14

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 522.2

42154 51.7

48285 470.5

D3290-3RevC

Manufactured No



Window

100  
160  
A

Each 6.0000 1.0000

2x

SAD 09-08-14

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 6

47693 6

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 2

August 12, 2009 8:14:10 AM

Work Order ID: 51241



Parent Item: D3290-041RevC



Parent Item Name: Replacement Window Assembly

Start Date: 08/12/2009

Required Date: 08/24/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			<del>100</del> 100	sf	155.3968	3.9474			

6061-T6 .040 Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 155.3968

100742 3.3

102723 7.93

105842 12

106747 12.5

107461 19.42

109396 22.28

111224 76.4668

19380 1.5

111224

WB 9-8-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	51241
<b>Description:</b> Window Frame		<b>Part Number:</b>	D3290-1
<b>Inspection Dwg:</b> D3290 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	X			
14.00	+/-0.030	14.00	X			
Ø0.171	+0.005/-0.001	.175	X			
1.50	+/-0.030	1.505	X			
1.11	+/-0.030	1.11	X			
10.10	+/-0.030	10.10	X			
18.50	+/-0.030	18.50	X			
0.040	+/-0.010	.042	X			
R3.00	+/-0.030	3.00	X			
R4.50	+/-0.030	4.50	X			
Ø0.257	+0.006/-0.001	.260	X			
13.61	+/-0.030	13.61	X			

<b>Measured by:</b> B	<b>Audited by:</b> D	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-8-12	<b>Date:</b> 09/06/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue      P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	B

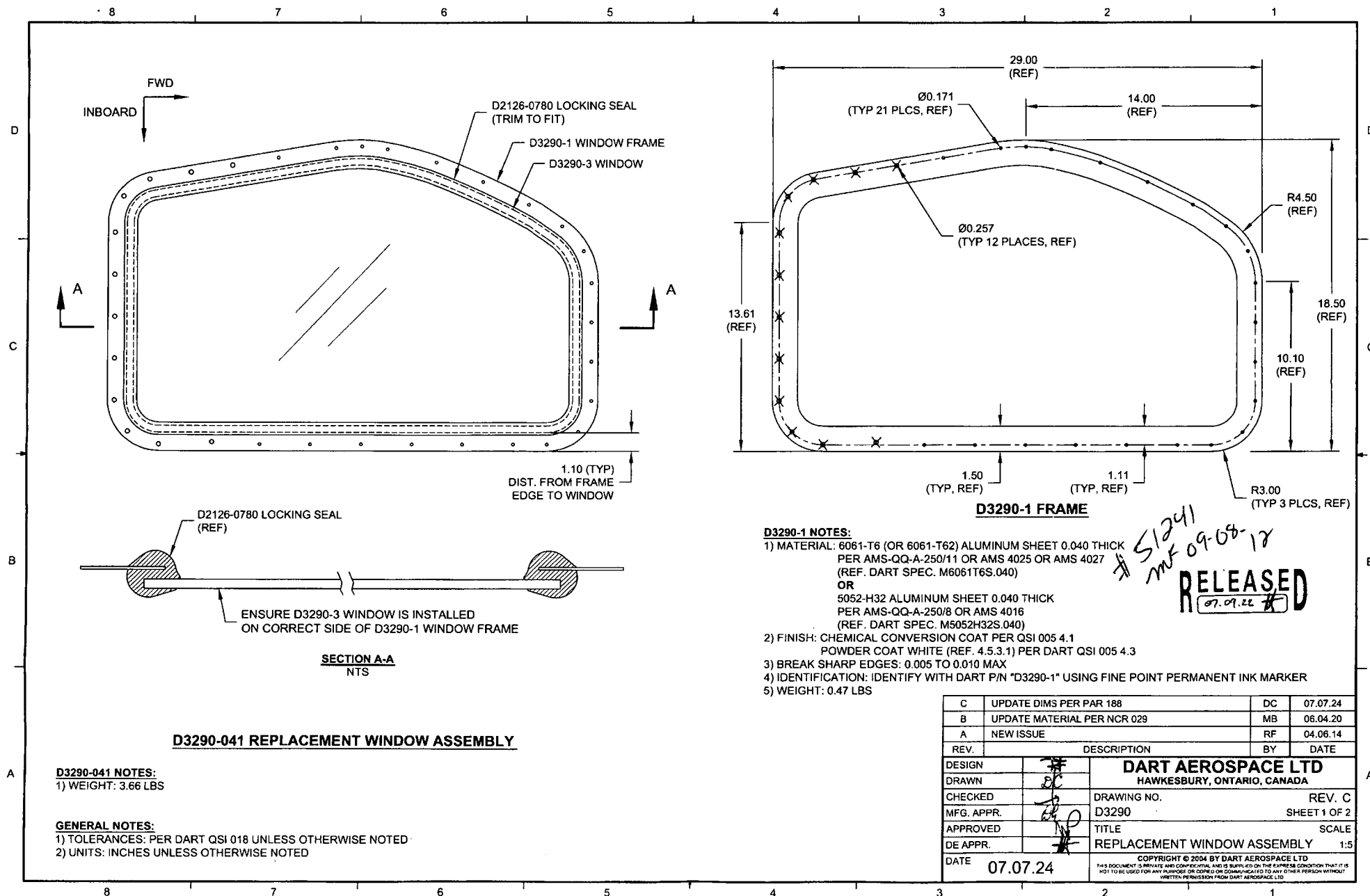
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3290	REV. C
TITLE REPLACEMENT WINDOW ASSEMBLY	SHEET 1 OF 2
SCALE 1:5	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

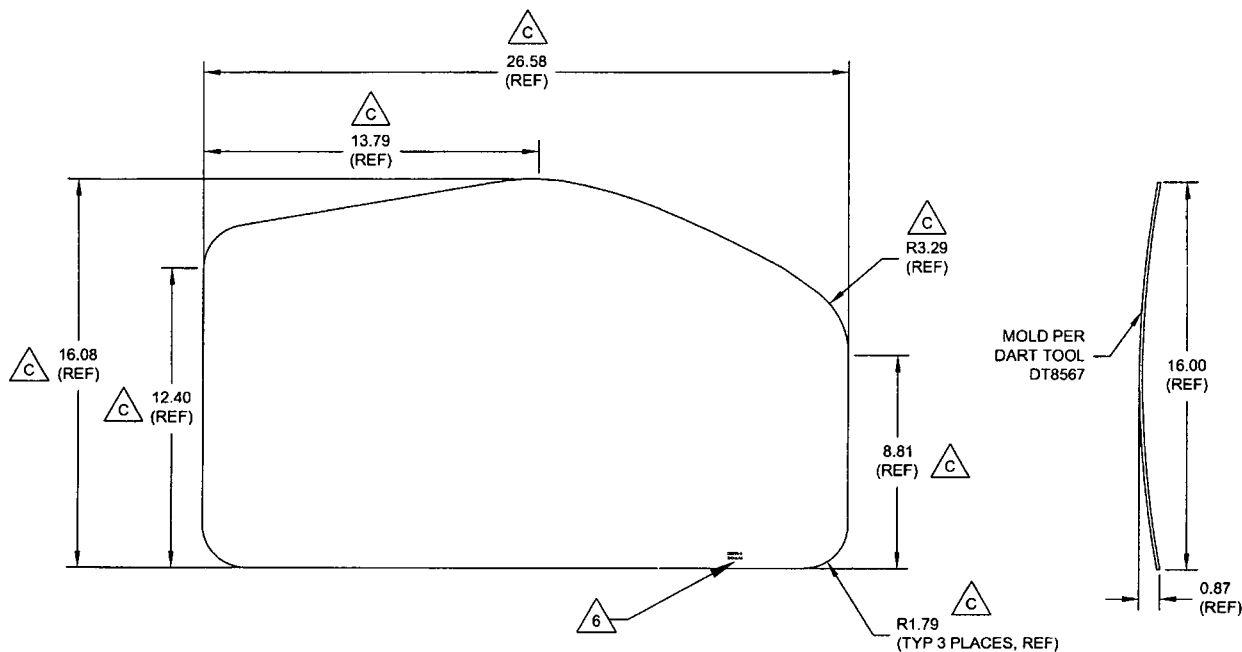
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





### D3290-3 WINDOW








#### D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

#51241  
WF  
09-08-12

RELEASED  
07.07.22

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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